

Work Order ID 74960

74960

~~PROTOTYPE~~

Page 1

Thursday, October 13, 2011 1:35:39 PM

Item ID: D4165-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Inner Door Panel
 Start Date: 10/13/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/18/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 11-10-13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4165	B								

100 0.00

100
 Waterjet B11-10-17
 FLOW CNC Waterjet
 2024.040
 Memo
 1-Cut as per Dwg
 Dwg Rev: B
 Prog Rev: B
 2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110
 QC B11-10-17
 Quality Control
 Memo

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74960

Thursday, October 13, 2011 1:35:39 PM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 10/13/2011 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 10/18/2011 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID**Tool #**

Plan Code

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

QC8- Inspect parts - second check

0.00 inserted to Rev B

120

0.00

QC

Memo

Quality Control

Chemical Conversion Coat per QSI005 4.1

0.00

130

0.00

HandFinish

Memo

Hand Finishing

QC3- Inspect Part Finish

0.00

135

0.00

QC

Memo

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Page 3

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <i>ST</i>	0.00							
140									
Packaging	Memo	0.00							<i>SP 11-11-04</i>
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							<i>11/11/04</i>
Quality Control									

10/17/11 04
2392
11/11/04

11/11/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Thursday, October 13, 2011 1:35:44 PM

Page 1

Work Order ID: 74960

74960

Parent Item: D4165-3

D4165-3

Parent Item Name: Inner Door Panel

Start Date: 10/13/2011

Required Date: 10/18/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.03.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	150.2184	3.58	3.768421			

M2024T3S 040

2024-T3 .040 sheet

B11-10-17

Location

Loc Qty

Loc Code

MAT022

150.218421

113162

1.1

117684

149.118421

117684

①

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74960
~~14795~~

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: <u>B</u>	Audited by: <u>S</u>	Preliminary Approval:
Date: <u>11-10-17</u>	Date: <u>11/10/17</u>	Date:

Rev	Date	Change	Revised by	Approved
A	11.04.28	New Issue	KJ	M

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

RD2392

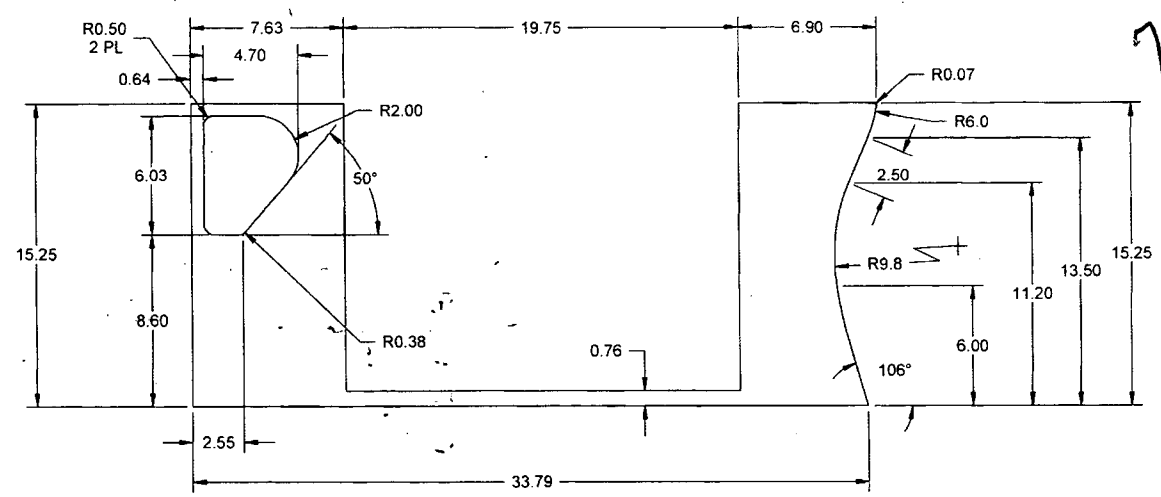
14

RD 2392

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. ~~74796~~

M.G.J.
11/10/12

7496



D4165-3 INNER DOOR PANEL
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-18)

- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.75 lbs

RELEASED
2011-04-15

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D4165	REV. B
MFG. APPR.		SHEET 2 OF 7	
APPROVED		TITLE	SCALE
DE APPR.		VRD PARTS	NTS
DATE	11.04.11	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	